

Date: Thursday, 9/14/2006 7:30:06 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : EYEBALL ADAPTER
<b>Job Number</b> : 28575	
<b>Estimate Number</b> : 12237	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D34803
<b>This Issue</b> : 9/14/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3480 REV.A <i>UNDER REVIEW</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : A <i>OK</i> { SEE HAND CHANGE A1
<b>Previous Run</b> : 27000	<b>Material</b> : N/A <i>OK</i> { SEE 06-09-10
<b>Written By</b> : _____	<b>Due Date</b> : 10/6/2006 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : est rev. A 06.02.07 new issue EC Est. Rev B Now on Water jet 06.04.18 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S26GA	304/316 0.018 SHEET
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**Comment:** Qty.: 0.0662 sf(s)/Unit Total : 0.2646 sf(s) *m100817*

AISI 304/316 0.018 SHEET

Batch: ~~060920~~ *06 09 20*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET

Cut as per dwg D3480

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Roll as per dwg D3480

2-Spot weld as per dwg D3480

*MF 06/10/05* (4)

*MF 06/10/05* (4)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:    Date: 06/10/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/14/2006 7:30:06 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EYEBALL ADAPTER

Job Number: 28575

Part Number: D34803

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

SB 06/10/05

(4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

GA

TOO R SB 06/10/05

2

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 06/10/06

(2)

Job Completion



U 06/10/06

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

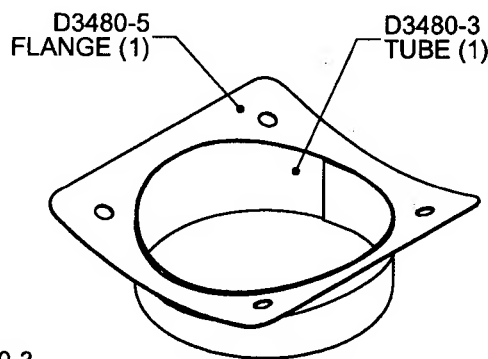
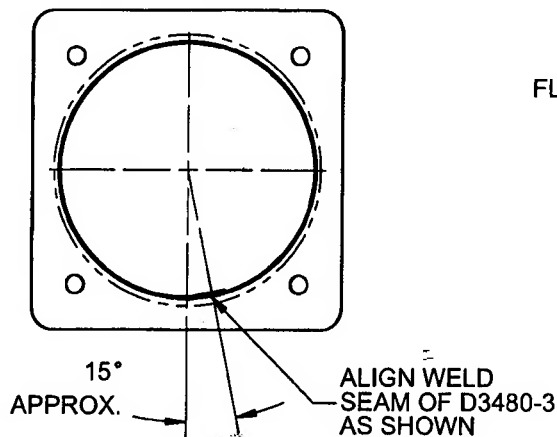
**NOTE:** Date & initial all entries



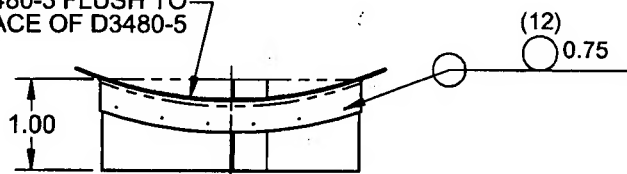
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3480</b>	REV. A SHEET 1 OF 6
DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2
A	06.02.06	NEW ISSUE	

*06.04.03*

**UNDER REVIEW**  
*06.05.17*



SPOT WELD PARTS, THEN  
CUT D3480-3 FLUSH TO  
SURFACE OF D3480-5



### D3480-041 EYEBALL INLET ADAPTER

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *28575*

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-041 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3480-041	EYEBALL INLET ADAPTER
1	D3480-3	TUBE
1	D3480-5	FLANGE

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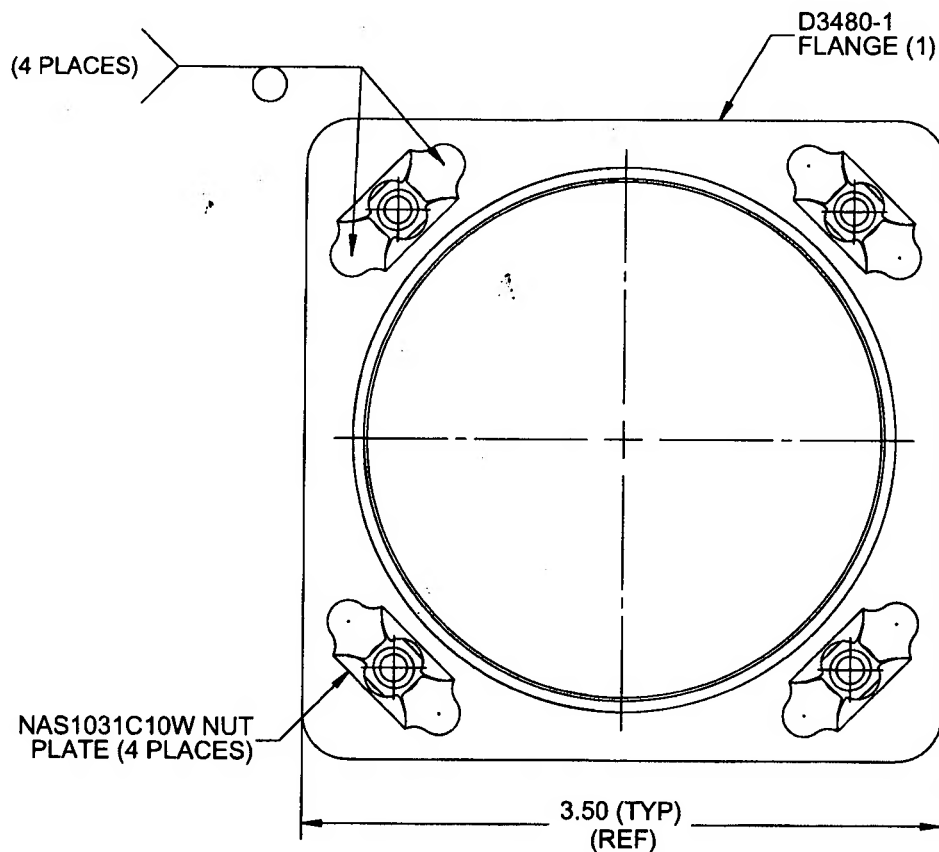
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DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b> SCALE 1:1	

**UNDER REVIEW**  
*06.07.12*



**D3480-043 EYEBALL ADAPTER**

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WITHOUT NOTICE  
WORK ORDER  
NO. *28575*

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) IDENTIFY WITH DART P/N D3480-043 USING FINE POINT PERMANENT INK MARKER
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

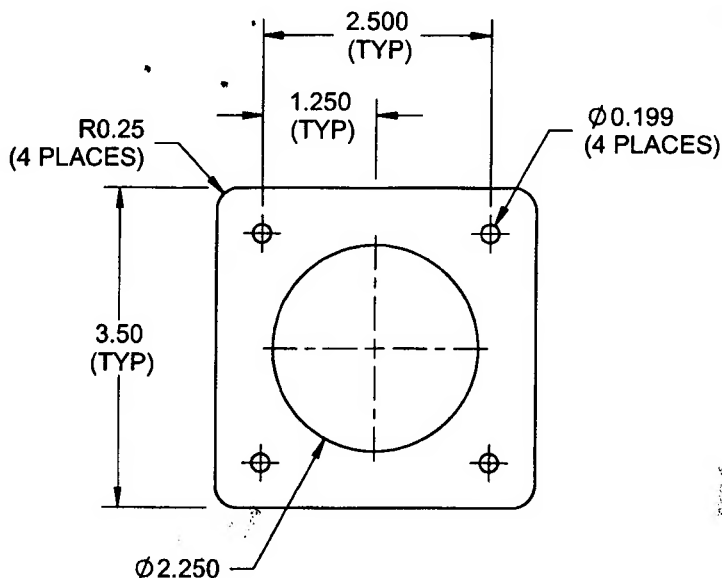
QTY -041	P/N	DESCRIPTION
X	D3480-043	EYEBALL ADAPTER
1	D3480-1	FLANGE
4	NAS1031C3W	NUTPLATE

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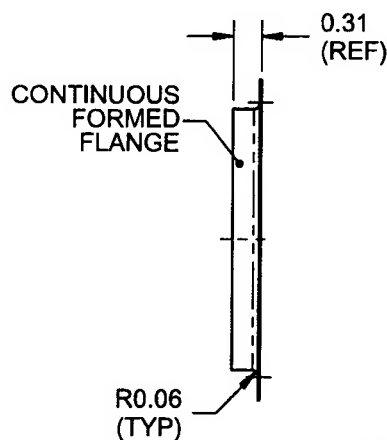
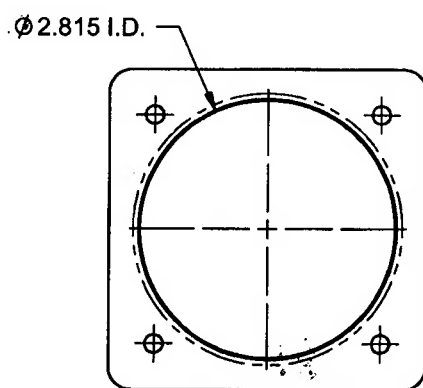
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DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2



**UNDER REVIEW**  
*[Signature]* 06.05.17

*[Signature]* 06.04.03

### D3480-1F FLAT PATTERN



### D3480-1 FLANGE (MAKE FROM D3480-1F)

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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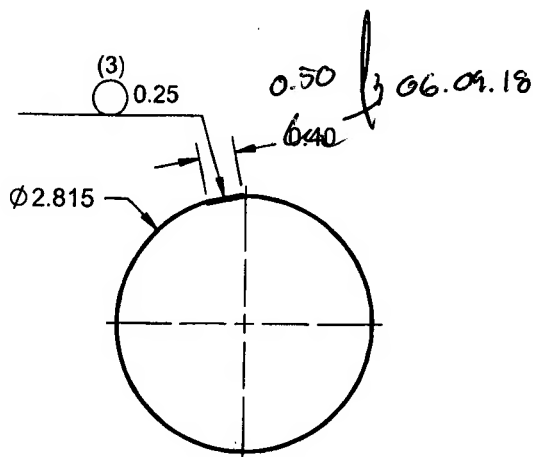
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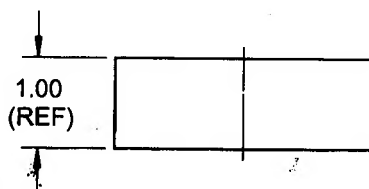
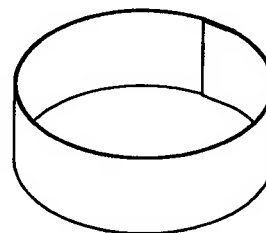


**DART**

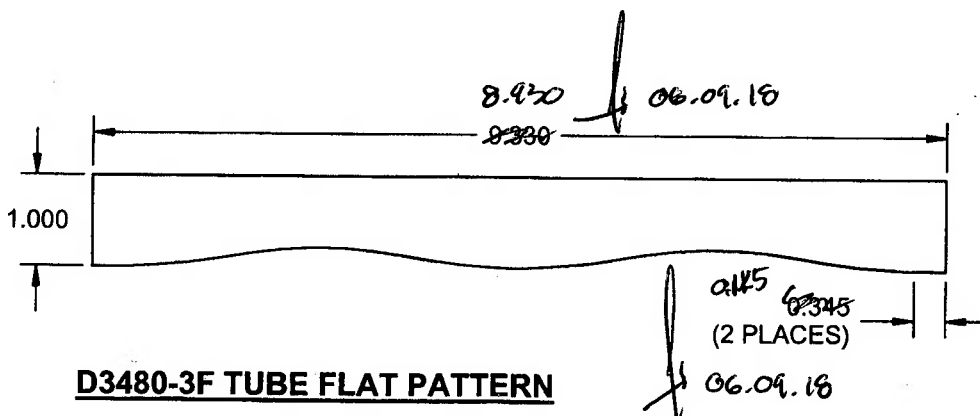
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DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2



**UNDER REVIEW**  
06.05.17



**D3480-3 TUBE**



**D3480-3F TUBE FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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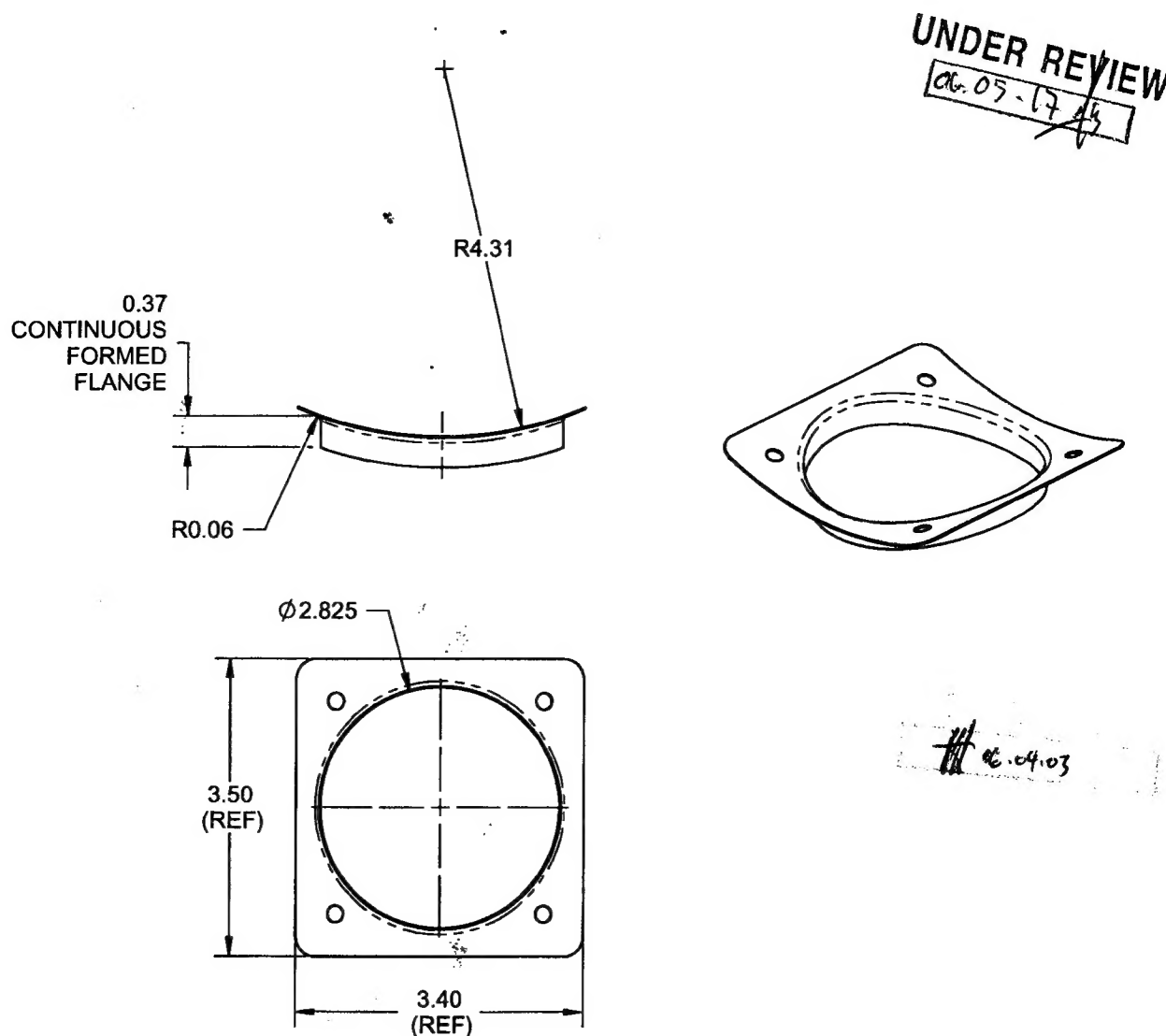
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DATE 06.02.06		TITLE EYEBALL ADAPTER	SCALE 1:2



### D3480-5 EYEBALL ADAPTER FLANGE

#### NOTES:

- 1) MATERIAL: MAKE FROM D3480-1F
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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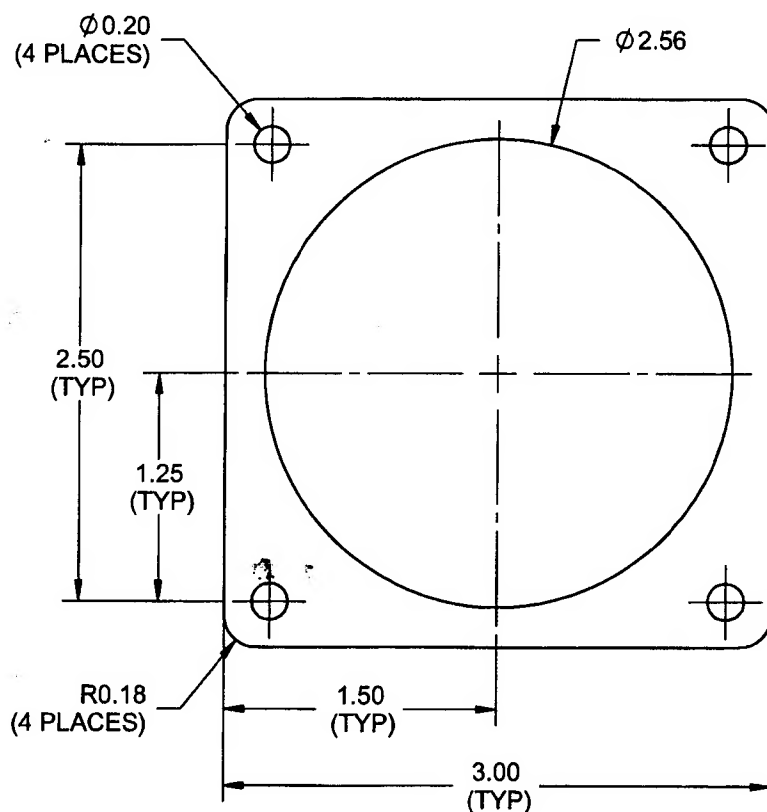
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DATE <b>06.02.06</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:1

**UNDER REVIEW**  
*[Signature]* 06.03.07



*[Signature]* 06.04.03

**D3480-7 GASKET**

**NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.125" THICK (REF. DART SPEC. M-SIL60-.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 29

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Melanie Faure  
Joint Welding Procedure Spot Welding  
Part number and Job number D 3480-3 B 28575

TEST WELDS REQUIRED

BASE METAL	<u>304</u>	<u>2G</u>	WELDING PROCESS	
Penetration	Complete <input checked="" type="checkbox"/>	Partial <input type="checkbox"/>	Single Weld <input type="checkbox"/>	Double Weld <input type="checkbox"/>
Current	AC <input type="checkbox"/>	DC <input checked="" type="checkbox"/>	Backing YES <input type="checkbox"/>	NO <input checked="" type="checkbox"/> N/A
	Position		Vertical Down <input type="checkbox"/> Up <input type="checkbox"/>	
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>
Crossbolt Spacer Welded into			Skidtube	

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☐ Fail ☐ N/A

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/05 Qualifier Sylvie Boucler

